

# Work Order ID 57143

Tuesday, March 23, 2010 4:08:13 PM



ASAP

Page 1

Item ID: D3953-17

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Spacer

Start Date: 3/24/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 3/29/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-3-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3953	C
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100

Waterjet

FLOW CNC Waterjet

304 .375x 3.00

Memo

1-Cut as per Dwg D3953

Dwg Rev: C

Prog Rev: C

2-Drill holes as per dwg

3-Deburr if necessary

0.00

0.00

B 10-3-30

18

EP 10/03/31 18

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC

Memo

0.00

Quality Control

B 10-3-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 3/24/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 3/29/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Sub 04/01

0.00

Memo



130



Small Fab

Small Fab

Memo  
1- OPEN HOLES AS PER DWG  
2- DEBURR IF NECESSARY

0.00

0.00

EB-

10/04/01 (18)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Sub 04/01

Memo



W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start

Revision ID:

Stop

Item Name: Gas Spring Spacer

Start Date: 3/24/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 3/29/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: 151

0.00



Packaging

Memo

0.00

Packaging

*Pickup 151*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/04/06**ME**10-4-5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, March 23, 2010 4:08:13 PM

Page 1

Work Order ID: 57143



Parent Item: D3953-17



Parent Item Name: Gas Spring Spacer

Start Date: 3/24/2010

Required Date: 3/29/2010

Comments: IPP RevA: New issue DD verified by:EC  
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.375X03.000		Purchased	No			100	f	11.5800	0.3947	6		



M304 SS bar .375 x 3.00



13 10-3-30

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

11.58

111369

3.98

113679

7.6

113679

18

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





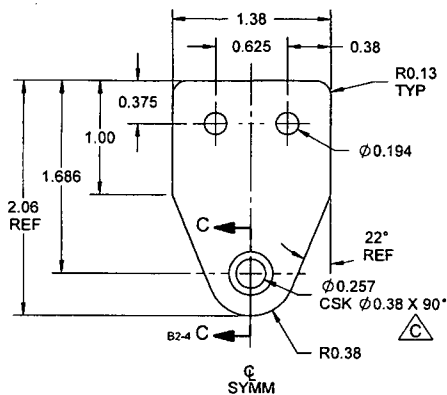
W/O:		WORK ORDER CHANGES					
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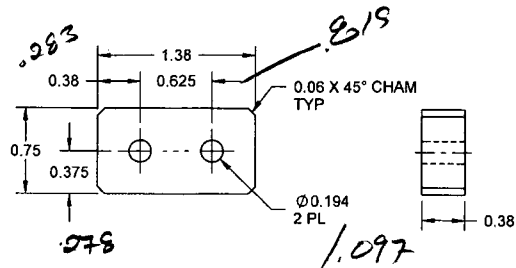
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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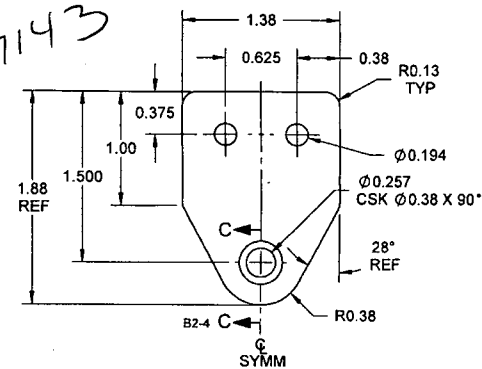
**NOTE:** Date & initial all entries



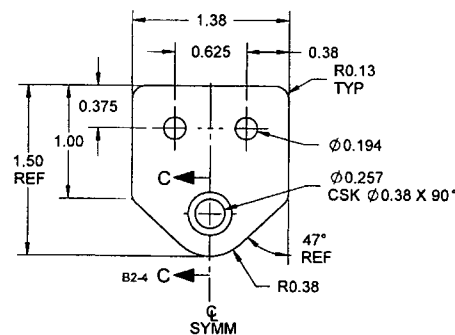
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



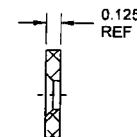
**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)



**SECTION C-C**

**NOTES:**

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

-19: 0.07 lbs

-21: 0.06 lbs

**RELEASED**  
2010-02-26

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3953</b>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	10.01.29	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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